

FORM

UPC



0 47700 25716 7

C6649107

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

Remington



VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM M24

SERIAL NO.
C6649107

ORDER NO.
5716

20

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.



5716 C6649107

ORDER 5716

MODEL 700TM M24

UPC



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ORDER 5716

MODEL 700TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649107

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action		OCT 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	JS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/13/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12-4-91	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-4-91	RY
	G) Safety Off Force	2	2	2			12-4-91	RY
	H) Trigger Pull Test & Retainability						12-4-91	RY
	I) Firing Pin Indent	.0205	.0205	.0205			12-4-91	RY
	J) Assemble Stock						12/5/91	RW
	K) Assemble Swivel Studs						12-4-91	Ac
	L) Attach Front and Rear Sight Assemblies						12/5/91	RW
	M) Iron Sight Alignment						12/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/5/91	RW
	O) Attach Scope to Rifle						12/5/91	RW
	P) Detach & Attach Scope 20 Times						12/5/91	RW
640	Gallery Target & Test						12-5-91	AC
	A) Time						12-5-91	AC
	B) Malfunctions						12-5-91	AC
	C) Pierced Primers						12-5-91	AC
	D) Optical Clarity of Scope						12-5-91	AC
645	Inspect for Live Ammo						12-5-91	AC
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	2.51	2.45	2.23	2.20	2.58	12-7-91	D/H
	C) Function						12-7-91	AC
660	Pack						12-20-91	RV

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6649107

DATE 12-4-91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.55	2.51	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.38	2.39	2.45	
PULL #3	2.53	2.53	2.44	2.23	
PULL #4	2.59	2.34	2.53	2.20	
PULL #5	2.52	2.55	2.51	2.58	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.52		
PULL #2	3.49	3.46		
PULL #3	3.39	3.44		
PULL #4	3.49	3.52		
PULL #5	3.49	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.38		4.44
PULL #2	4.25	4.54		4.52
PULL #3	4.29	4.38		4.52
PULL #4	4.43	4.38		4.27
PULL #5	4.56	4.53		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649107
5 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.407039
1 TO	2	.635938
1 TO	3	.235136
1 TO	4	.004
1 TO	5	.362609

34 ³ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.262
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0668
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .27038
POI RADIUS FOR THIS RIFLE IS: 1.027

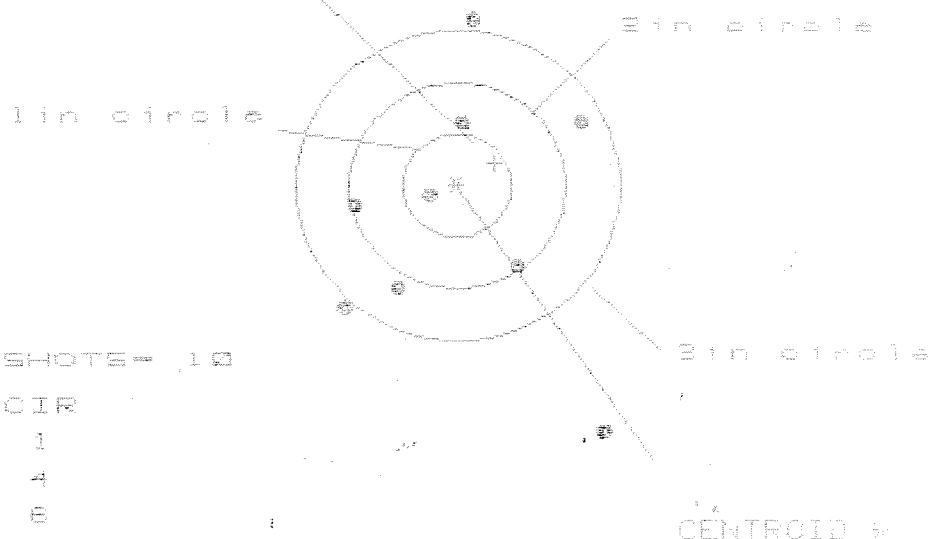
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FILE:/PATTERNING/CENTERFIRE_PATT/08649187

CENTERFIRE PATTERNS

1

FOR



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 2.428

VS= 5.318

GS= 5.615

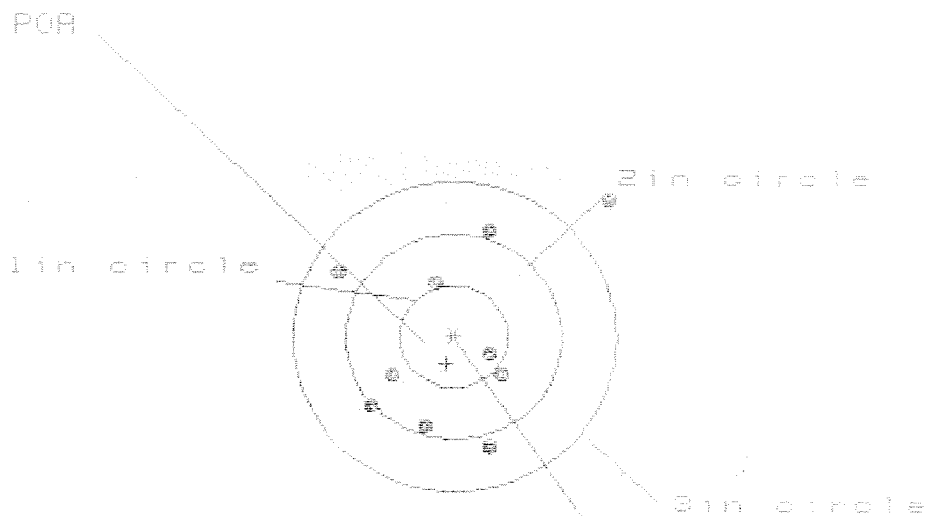
CENTROID

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.342	1.291	1.259
MINIMUM X	:	-1.086	-1.137	-1.975
MAXIMUM Y	:	2.892	1.897	1.634
MINIMUM Y	:	-2.426	-2.105	-1.170
CENTROID X	:	-.345	-.294	-.456
CENTROID Y	:	-.216	-.537	-.274
FOR TO CENTROID in.	:	.407	.612	.532
1 in RADIUS	:	.237	.358	.114
2 in RADIUS	:	1.414	1.238	1.034
3 in RADIUS	:	2.928	2.470	1.652
HORIZONTAL SPREAD	:	2.428	2.428	2.234
VERTICAL SPREAD	:	5.318	4.002	2.804
DIAGONAL SPREAD	:	5.615	4.179	3.050
SHOTS IN ONE INCH CIRCLE	=	1		
SHOTS IN TWO INCH CIRCLE	=	4		
SHOTS IN THREE INCH CIRCLE	=	6		

08/1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HE= 2.427

VS= 2.412

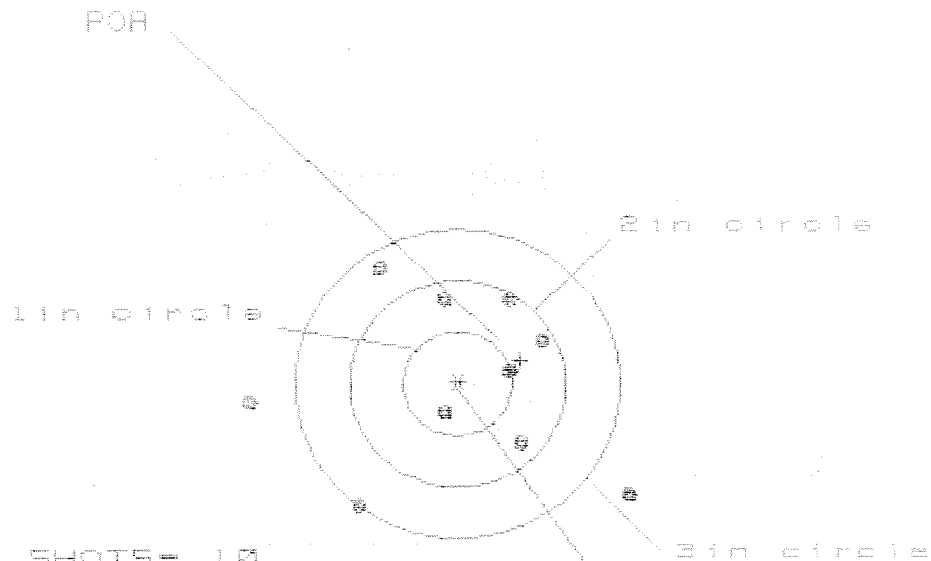
GS= 2.937

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.399	.631	.522
MINIMUM X	:	-1.028	-.872	-.597
MAXIMUM Y	:	1.369	1.137	1.235
MINIMUM Y	:	-1.043	-.891	-.793
CENTROID X	:	.071	-.085	.025
CENTROID Y	:	.265	.113	.015
POA TO CENTROID in.	:	.274	.141	.029
MIN RADIUS	:	.373	.467	.364
MEAN RADIUS	:	.948	.799	.731
ARC RADIUS	:	1.957	1.233	1.288
HORIZONTAL SPREAD	:	2.427	1.503	1.218
VERTICAL SPREAD	:	2.412	2.029	2.028
EXTREME SPREAD	:	2.937	2.134	2.028
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Dec 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.481

VS= 2.320

GS= 3.614

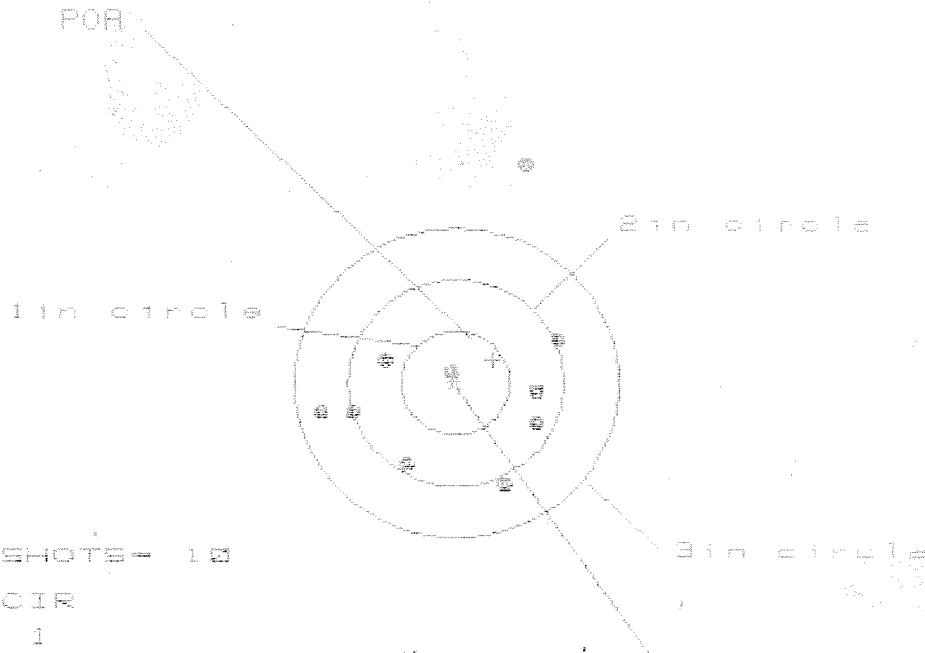
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.537	1.321	.732
MINIMUM X	:	-1.944	-1.115	-.950
MAXIMUM Y	:	1.155	1.139	.448
MINIMUM Y	:	-1.165	-1.181	-1.322
CENTROID X	:	-.580	-.354	-.529
CENTROID Y	:	-.224	-.208	-.067
POA TO CENTROID in.	:	.622	.419	.534
MIN RADIUS	:	.345	.249	.402
MEAN RADIUS	:	1.097	.966	.871
MAX RADIUS	:	1.949	1.738	1.620
HORIZONTAL SPREAD	:	3.481	2.436	1.681
VERTICAL SPREAD	:	2.320	2.320	2.320
EXTREME SPREAD	:	3.614	3.168	3.411
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Dec 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.175

VS= 3.033

GS= 3.066

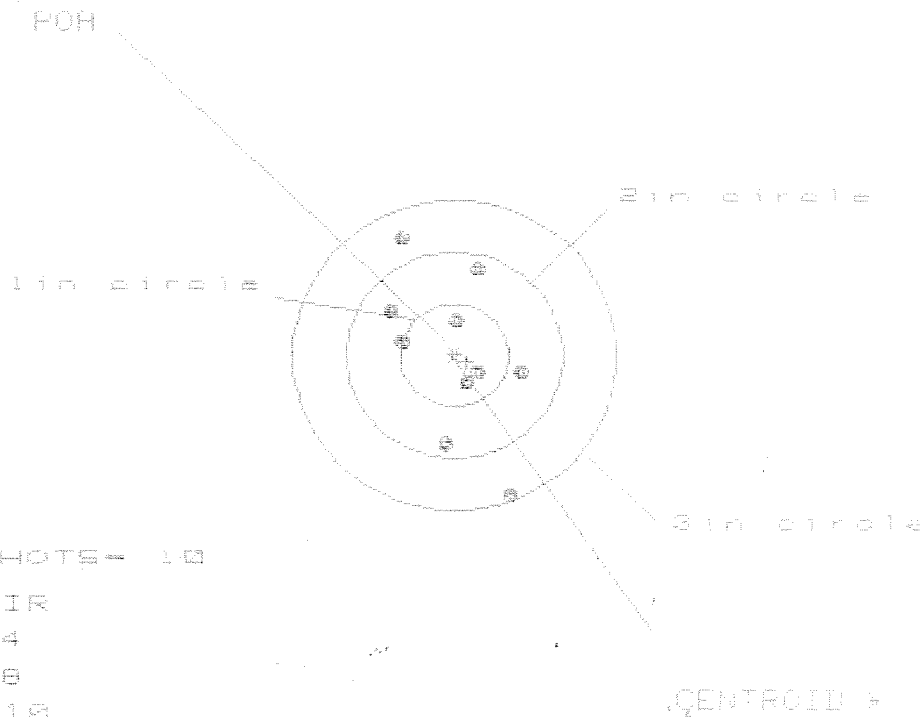
CENTROID +

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.898	.965	.814
MINIMUM X	-1.277	-1.210	-.994
MAXIMUM Y	2.085	.650	.641
MINIMUM Y	-.948	-.716	-.724
CENTROID X	-.345	-.412	-.261
CENTROID Y	-.220	-.452	-.443
FOR TO CENTROID in.	.409	.612	.515
MIN RADIUS	.097	.305	.331
MEAN RADIUS	.976	.629	.771
MAX RADIUS	2.172	1.212	1.026
HORIZONTAL SPREAD	2.175	2.175	1.808
VERTICAL SPREAD	3.033	1.366	1.366
EXTREME SPREAD	3.066	2.298	1.529
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

5 Oct 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 1.141

VS= 2.455

GS= 2.647

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.592	.648	.553
MINIMUM X	-.549	-.493	-.548
MAXIMUM Y	1.097	.947	.777
MINIMUM Y	-1.358	-1.025	-1.407
CENTROID X	-.111	-.167	-.121
CENTROID Y	.061	.211	.097
POH TO CENTROID in.	.127	.269	.176
MIN RADIUS	.265	.242	.237
MEAN RADIUS	.706	.617	.557
MAX RADIUS	1.446	1.042	.916
HORIZONTAL SPREAD	1.141	1.141	1.141
VERTICAL SPREAD	2.455	1.972	1.972
EXTREME SPREAD	2.647	2.005	2.005
NUMBER IN ONE INCH CIRCLE =	4	4	4
NUMBER IN TWO INCH CIRCLE =	6	6	6
NUMBER IN THREE INCH CIRCLE =	10	10	10